

INSTALLATION INSTRUCTIONS

WARNING: NEVER EXCEED YOUR VEHICLE MANUFACTURER'S RECOMMENDED TOWING CAPACITY

R20 5TH WHEEL ROLLER



WARNINGS

Read and understand instructions before using this product. Fully instruct and demonstrate the operation of this 5th wheel hitch to the end user. Include the importance of observing all warnings contained herein, including warning labels on 5th wheel hitch mid section. Provide this manual in its entirety to the end-user.

To avoid serious injury, do not expose hands, body parts or clothing between the truck and trailer or the truck's bed sides and trailer. Extreme care should be observed to avoid serious injury to self, property and observers.

Never position yourself or others under the trailer's kingpin area during coupling and uncoupling. Serious injury or death may result if the warning above is not observed.

This product complies with V-5 regulations and safety requirements for connecting devices and towing systems of the State of Wisconsin.

UNPACKING THE ROLLER

Inspect all parts for damage and verify that all items listed are present. **NOTE:** The mounting rail kit (11) is sold separately.

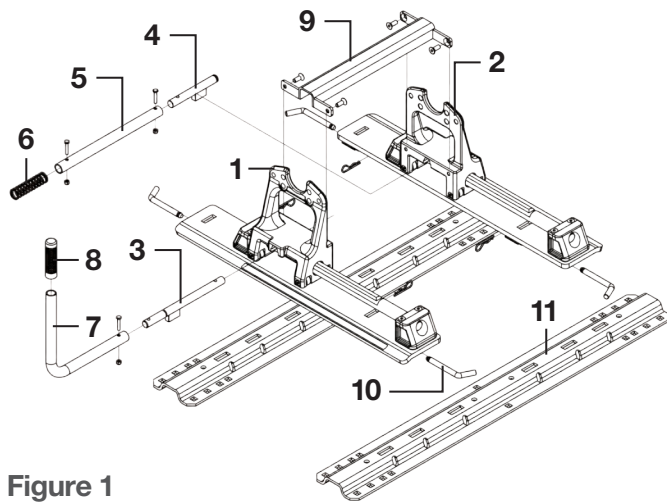


Figure 1

PARTS LIST

Item#	Qty	Description
1	1	Roller assembly, driver side (DS)
2	1	Roller assembly, passenger side (PS)
3	1	Lock rod weldment, driver side (DS)
4	1	Lock rod weldment, passenger side (PS)
5	1	Outer tube
6	1	Compression spring
7	1	Handle
8	1	Handle grip
9	1	Cross member weldment
10	1	Bolt kit
11	1	Mounting rail kit, ordered separately

ASSEMBLY INSTRUCTIONS

The R20 roller is to be used with 5th wheel trailers weighing up to 20,000 lbs. Never use on trailers exceeding 20,000 lbs.

CAUTION: The R20 roller will reposition your 5th wheel hitch 12" rearward. However, this will not guarantee complete truck cab/trailer clearance when towing.

Step 1

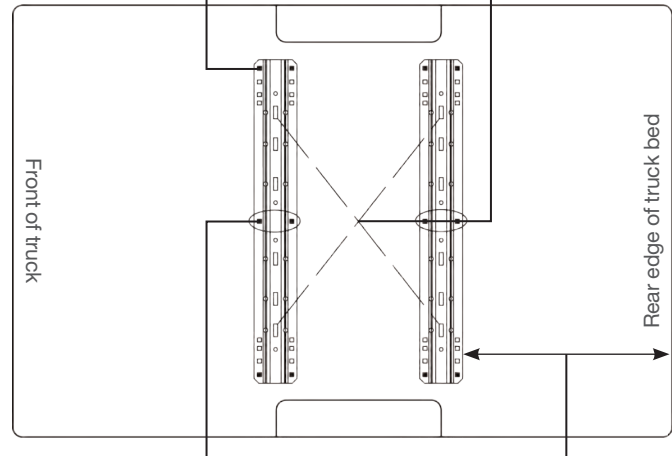
Before beginning assembly of the R20 roller, check the base rails in your truck to be sure they are properly installed and are parallel with each other. The diagonal dimensions should be the same, see Figure 2. With the base rails correctly positioned, the assembled R20 roller will drop into the slots on the top surface of the base rails.

Step 2

Grease the ends of the lock rod weldments (3) and (4) as shown in Figure 3.

Ensure rail kits are installed according to rail kit manufacturer's recommended specifications

Measure diagonal from same reference point. Measurement should be the same



Each mounting rail must have a bolt in either of the marked holes. Check for obstructions before drilling

Rear edge of truck bed to rear edge of mounting rail

Figure 2

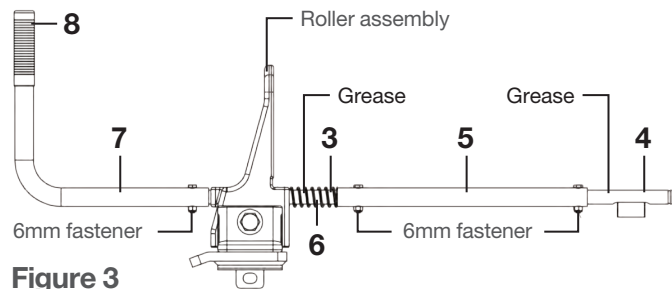


Figure 3

Step 3

Slide lock rod weldment (3) into the driver side (DS) roller assembly and slide lock rod weldment (4) into the passenger (PS) roller assembly.

Step 4

Slide the outer tube (5) over lock rod weldment (4) until holes line up. Secure with 6mm fastener. Tighten until nylock nuts are fully engaged.

Step 5

Slide compression spring (6) over lock rod weldment (3).

Step 6

Slide lock rod weldment (3) with compression spring (6) into outer tube (5) until the holes line up. Secure with 6mm fastener. Tighten until nylock nuts are fully engaged.

Step 7

Slide handle (7) over lock rod weldment (3) until the holes line up. Secure with 6mm fastener. Tighten until nylock nuts are fully engaged.

Step 8

Slide cross member weldment (9) between the DS roller assembly (1), PS roller assembly (2) and over the lock rod assembly as shown in Figure 1. Secure with 10mm flat head bolts and torque to 35 foot lbs.

Step 9

Place the assembled R20 roller into the base rails and pin in place with the supplied hitch pins & clips.

CAUTION: Be sure that all base rail hitch pins are positioned as shown in Figure 4 below and that all clips are secured before towing.

Base rail hitch pin illustration

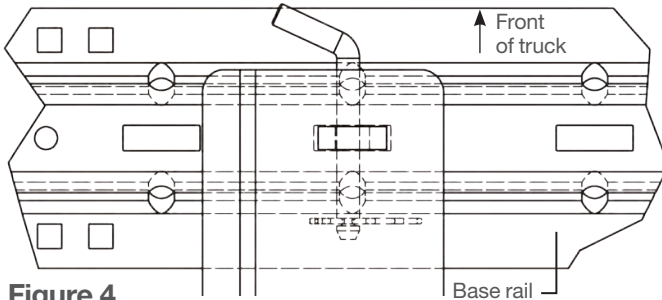


Figure 4

Step 10

Pull handle out and rotate as shown on the operation decal on the roller. Roller should move smoothly fore and aft on the rails. **NOTE:** When the R20 roller is locked in its fore and aft positions the lock bar handle should be vertical. The red indicator will not be showing and the green indicator will be showing. See Figure 5 below.

Step 11

If the unit binds, make sure all bolts are torqued to proper specifications. Make sure base rails are square and parallel.

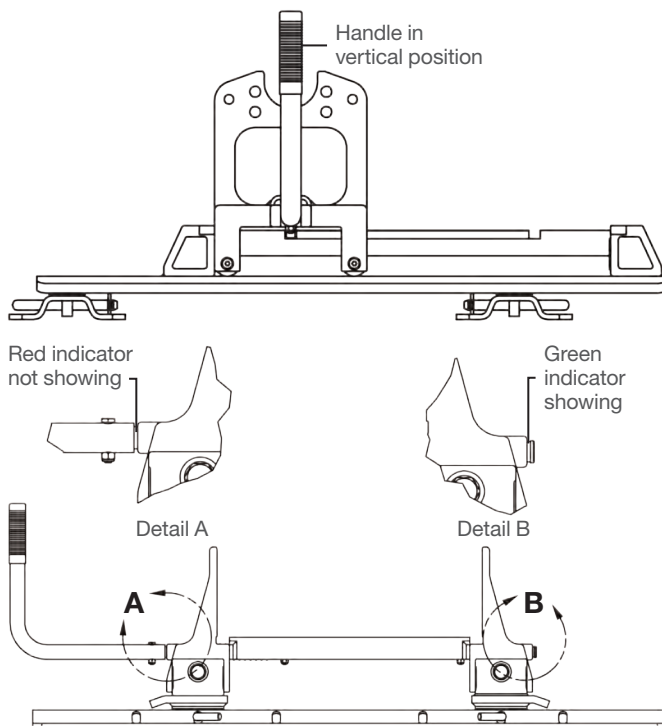


Figure 5

5TH WHEEL HEAD INSTALLATION

Install the 16530 5th wheel head by sliding it into the R20 roller, as shown below. Select desired height using the adjustment holes in the mid section of the 5th wheel head. From the inside, secure the head unit to the R20 roller with the four 14mm bolts supplied. Torque to 100 foot lbs. Your R20 is now ready for operation. See 'Operation Instructions'.

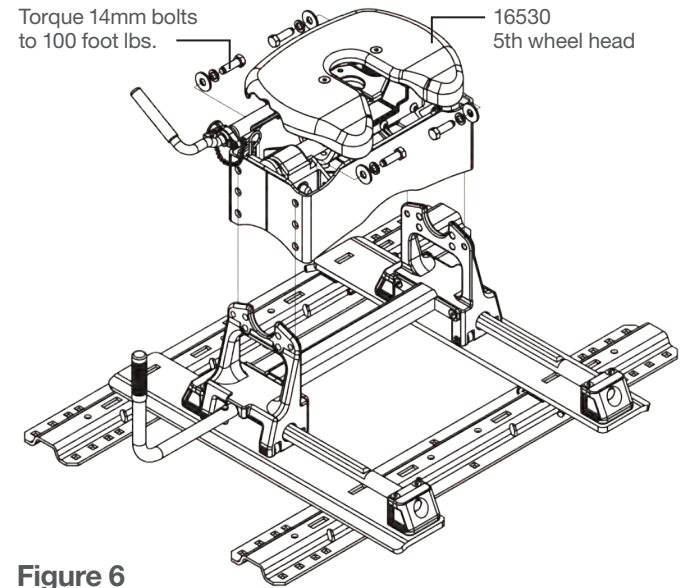


Figure 6

REMOVAL OF THE 16530 HEAD & 16550 ROLLER

For removal of the 16530 5th wheel head from the R20 roller, reverse the steps found under the '5th Wheel Head Installation' above.

For removal of the 16550 R20 roller, reverse steps 3 through 9 found under the 'Assembly Instructions' on the previous page. Also see Figures 3 and 4.

OPERATING INSTRUCTIONS

To maneuver

Align trailer and tow vehicle in a straight line, on a level surface.

Pull handle out and rotate counter-clockwise to place lock bar in the ready-to-lock position.

Set trailer brakes and slowly drive the tow vehicle forward until R20 roller stops. Locking bars will automatically engage in the rear locking groove. **NOTE:** Visually check that lock bar handle is vertical, both lock bars are fully engaged and that the green indicator is visible.

Maneuver position

Roller and hitch will move 12" rearward

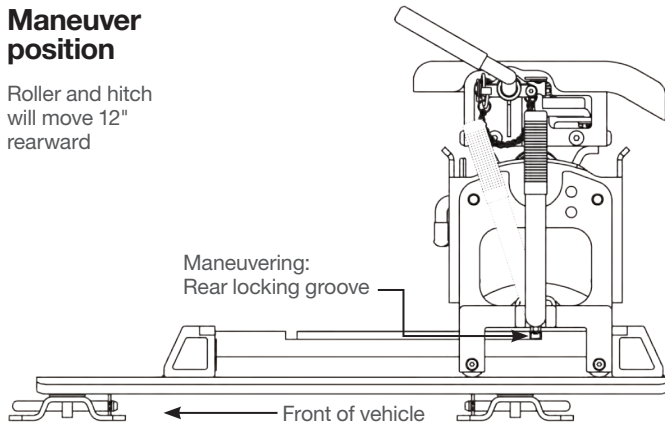


Figure 7

To tow

Align trailer and tow vehicle in a straight line, on a level surface.

Pull handle out and rotate clockwise to place lock bar in the ready-to-lock position.

Set trailer brakes and slowly back up the tow vehicle until R20 roller stops. Lock bars will automatically engage in the forward locking groove. **NOTE:** Visually check that lock bar handle is vertical, both lock bars are fully engaged and that the green indicator is visible. Set trailer brakes and move the tow vehicle forward slightly to be sure both lock bars are fully engaged. You are now ready to tow.

Towing position

Roller and hitch will move 12" forward

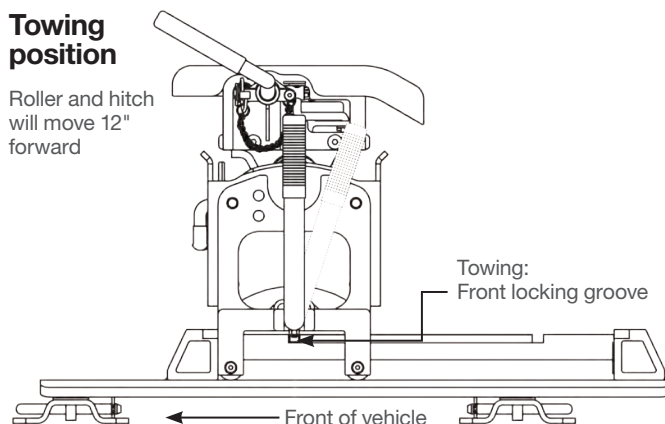


Figure 8